

Page 1

DAS
25
9-89

**DAS
25
9-88**

DAS
14
9-89

15/05/00

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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OTHER : _____																					

Work Order ID 131692

Tuesday, April 21, 2015 1:46:21 PM

131692

Page 3

Item ID: D2933-2 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle RH In, 206
Start Date: 4/20/15 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 4/20/15 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							DAS 38 9-88
160									
QC	Memo	0.00							
Quality Control									MAY 27 2015
170	Identify as per dwg & Stock Location: <u>st396</u>	0.00							DAS 27 9-88
170									
Packaging	Memo	0.00							
Packaging									MAY 28 2015
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.01							
Quality Control									MAY 28 2015

MLJ MAY 28 2015

DQA: _____ Date: _____



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Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
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Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER :							
Misidentified ☐	Past Due ☐								

Picklist Print

Tuesday, April 21, 2015 1:46:21 PM

Page 1

Work Order ID: 131692

131692

Parent Item: D2933-2

D2933-2

Parent Item Name: Saddle RH In, 206

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP: B00.06.26New DWG rev (mpp 2069)EC
IPP Rev:C As per Rev C 07-03-19 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-001		Manufactured	No			100	Each	47.0000	1	4			

D6101-001

Saddle Billet

Location

Loc Qty

Loc Code

MAT042

40

129986

40

MAT045

7

125829

7

4 JFC 2015-04-29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
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Description Work Order Deviation		Disposition		Completed By	
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OTHER : _____					

DART AEROSPACE LTD	Work Order:	131692
Description: 206 Saddle, Inboard, Right side	Part Number:	D2933-2
Inspection Dwg: D2933 Rev. C		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2933 Rev. C and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.100	0.140		127	126	127	127		
B	0.100	0.140		127	126	127	127		
C	0.100	0.140		120	118	120	119		
D	0.210	0.230		223	223	223	223		
E	1.245	1.255		1.250	1.250	1.250	1.250		
F	1.245	1.255		1.250	1.250	1.250	1.250		
G	2.495	2.505		2.500	2.500	2.500	2.500		
H	0.510	0.515		512	512	512	512		
I	1.572	1.582		1.577	1.577	1.577	1.577		
J	2.495	2.505		2.500	2.500	2.500	2.500		
K	0.257	0.262		258	258	258	258		
L	0.312	0.317		313	313	313	313		
M	0.235	0.240		239	239	238	239		
N	0.100	0.140		122	122	123	122		
O	0.540	0.560		549	549	548	548		
P	0.490	0.510		499	500	501	500		
Q	3.715	3.725		3.720	3.720	3.720	3.720		
R	2.470	2.510		2.495	2.495	2.495	2.495		
S	0.240	0.270		249	248	248	248		
T	0.100	0.180		140	140	140	140		
U	1.625	1.635		1.630	1.630	1.630	1.630		
V	1.362	1.372		1.367	1.367	1.367	1.367		
W	0.316	0.321		316	316	316	316		
X	1.125	1.145		1.137	1.138	1.137	1.138		
Y	1.565	1.585	DT8695 A/B	1.577	1.578	1.577	1.578		
Z	0.178	0.198		188	188	188	188		
AA									
AB									
AC									
AD									
AE									
AF									
AG									
AH									
Accept/Reject									

Measured by: JL
Date: 15-4-30

Audited by: B.A.	DAS
Date: 15/04/03	08

9-89

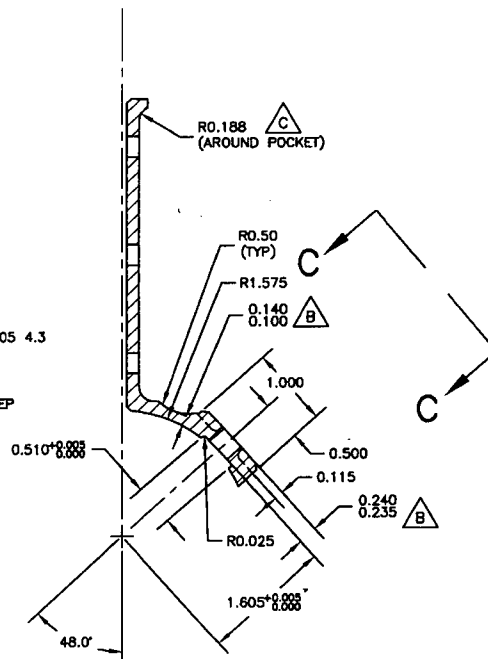
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.12.12	Re-format; Added Dim. X-Y, DT8683, DT8686, DT8690 & DT8695 A/B	KJ/RF	
C	07.03.21	Revised per drawing revision C	KJ/JLM	



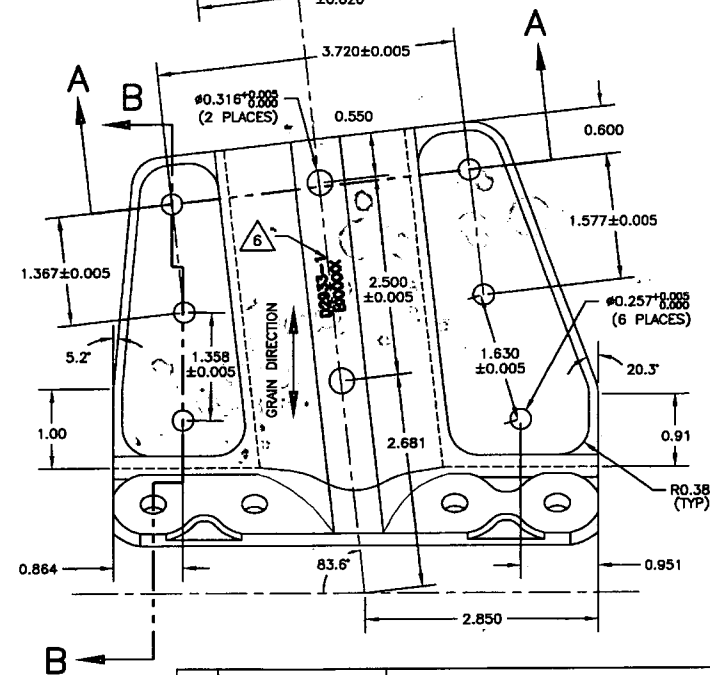
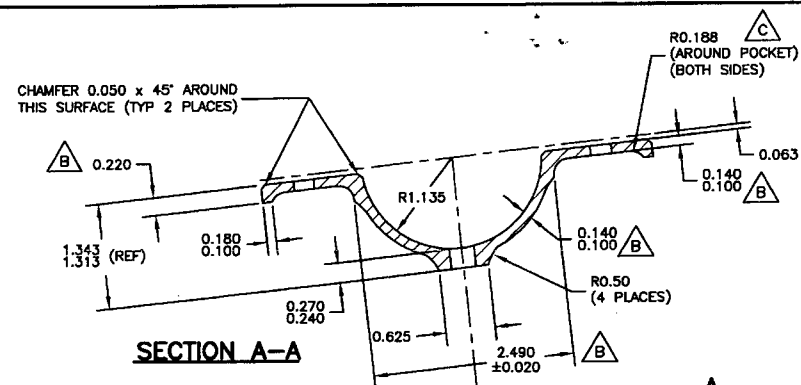
D2933-1 LH SADDLE (SHOWN)
D2933-2 RH SADDLE (OPPOSITE)

1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
3) BREAK ALL SHARP EDGES 0.010 TO 0.020
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
5) ALL DIMENSIONS ARE IN INCHES
6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA 0.010 TO 0.015 DEEP

CL15/04/23
W/O. 131692



SECTION B-B



C	06.11.09	R0.188 WAS R0.30 TO R0.25
B	00.05.29	CHANGED GEOMETRY AND MATERIAL
A	99.10.29	NEW ISSUE
DESIGN	DRAWN BY	 DART AEROSPACE USA, INC. BELLING, WA
CHECKED	APPROVED	
DATE	TITLE	
06.11.09	SADDLE INSIDE	REV. C SHEET 1 OF 1 SCALE 2:1

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OR COPIED OR COMMUNICATED TO ANY OTHER
PERSON WITHOUT WRITTEN PERMISSION FROM
DART AEROSPACE USA, INC.



Part Number: D2933-2	Rev: C	- Page 1 -
Description: SADDLE INSIDE	Inspection Dwg: D2933	Work Order: 131692

Name	Nominal	Upper Tol Lower Tol	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	
A	0.120	0.020 -0.020	0.127	0.126	0.127	0.127	
B	0.120	0.020 -0.020	0.127	0.126	0.127	0.127	
C	0.120	0.020 -0.020	0.120	0.118	0.120	0.119	
D Distance YZ	0.2200	0.0100 -0.0100	0.2229	0.2238	0.2244	0.2237	
E Distance XY	1.2500	0.0050 -0.0050	1.2501	1.2496	1.2499	1.2499	
F Distance XY	1.2500	0.0050 -0.0050	1.2491	1.2502	1.2500	1.2497	
G Distance XY	2.5000	0.0050 -0.0050	2.5001	2.4998	2.4998	2.4995	
H	0.510	0.005 0.000	0.512	0.512	0.512	0.512	
I Distance XY	1.5770	0.0050 -0.0050	1.5773	1.5774	1.5779	1.5772	
J Distance XY	2.5000	0.0050 -0.0050	2.4993	2.5001	2.4996	2.4999	
K Diameter	0.2570	0.0050 -0.0010	0.2579	0.2582	0.2578	0.2582	
L Diameter	0.3120	0.0050 -0.0010	0.3140	0.3137	0.3139	0.3139	
M	0.235	0.005 0.000	0.239	0.239	0.239	0.239	
N Distance YZ	0.1200	0.0200 -0.0200	0.1238	0.1247	0.1252	0.1243	
O Distance XY	0.5500	0.0100 -0.0100	0.5521	0.5517	0.5512	0.5509	
P Distance XY	0.5000	0.0100 -0.0100	0.4979	0.4982	0.4981	0.4983	
Q Distance XY	3.7200	0.0050 -0.0050	3.7186	3.7194	3.7188	3.7185	
R Distance XY	2.4900	0.0200 -0.0200	2.4953	2.4954	2.4955	2.4952	

Measured by:
Mathieu Lamarche

Date:
2015-5-9

Audited by:

Date:



Part Number: D2933-2	Rev: C	- Page 2 -
Description: SADDLE INSIDE	Inspection Dwg: D2933	Work Order: 131692

Name	Nominal	Upper Tol Lower Tol	No. Piece_1 Actual	No. Piece_2 Actual	No. Piece_3 Actual	No. Piece_4 Actual	
S	0.255	0.015 -0.015	0.249	0.248	0.248	0.248	
T	0.140	0.020 -0.020	0.140	0.140	0.140	0.140	
U Distance XY	1.6300	0.0050 -0.0050	1.6300	1.6305	1.6296	1.6297	
V Distance XY	1.3670	0.0050 -0.0050	1.3671	1.3669	1.3674	1.3672	
W Diameter	0.3160	0.0050 -0.0010	0.3156	0.3158	0.3158	0.3158	
X	1.135	0.010 -0.010	1.137	1.138	1.137	1.138	
Y	1.575	0.010 -0.010	1.577	1.578	1.577	1.578	
Z Radius	0.1880	0.0100 -0.0100	0.1951	0.1949	0.1950	0.1945	

Measured by:
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Date: